

CASE STUDY •**Application:** Stainless Steel Tubing**Material:** 304 Stainless Steel**Savings:** Eliminated Manual Deburring
3 Minutes Per Part**Industry:** Energy**Tool:** COFA 12

CHALLENGE: A customer in Tennessee faced the challenge of efficiently deburring stainless steel tubing with cross-drilled holes both inside and outside for a high-voltage bracket, using a Haas VG4 VMC machine. The material in question was 304 Stainless Steel, and the specific requirements included deburring hole sizes of .292", countersinks, and chamfers of .319". The customer aimed for a cycle time of 2 minutes per part, with a desired tool life of 200+ parts, each featuring 2 holes.

SOLUTION: In response to the challenge, Heule recommended the COFA12-504-Z deburring tool combined with the GH-C-M-0007 blade. This tool combination was chosen for its compatibility with the Haas VG4 VMC machine and its ability to effectively handle the specified materials and hole sizes. The suggested speeds and feeds for the tool were set at 110 SFM and .008" LPR, ensuring optimal performance.

OUTCOME: Heule's COFA12-504-Z deburring tool, paired with the GH-C-M-0007 blade, eliminated hand-deburring, enhancing efficiency on the Haas VG4 VMC machine. The customer achieved a substantial time saving of three minutes per part, surpassing their initial goal. This marked the first encounter with Heule for the customer, who was highly impressed with the tool's speed and consistent deburring results. Overall, Heule's solution not only met the specific project requirements but also delivered tangible benefits, showcasing the effectiveness of their tools in streamlining machining processes.

